



FUNCTION OF TOOL:

1. THE 14550145-1 HOLDING FUTURE WILL BE USED TO SECURE THE 145D5305 COLLECTOR GEAR. DURING INSTALLATION/REMOVAL OF THE 145D013-10 LOCUTUR IN THE 145D5300 C04B XP3N.
2. SHIM GEAR CENTRAL ON -1/2 PIMD DIA WHEN MAKING CERRO CAST.
3. MAKE FROM DIRECT CAST OF P/N 145D5305 COLLECTOR GEAR USING -16 DEVCON B PLASTIC STEEL RELEASE COAT P/N 145D5305 USING -17 LIQUID RELEASE AGENT.
4. BOLT & DOWEL CONST.
5. APPLY LIGHT COAT OF OIL PER MIL-L-7808 TO ALL STEEL SURFACES

6 STEEL STAMP (12 HIGH CHARACTERS) IDENT PLATE AS  
SHOWN BELOW:  
P/N 145G0145-1  
NAME \_\_\_\_\_  
CONTR N° \_\_\_\_\_  
INSP \_\_\_\_\_  
SIN \_\_\_\_\_

7. TOLERANCES: .X  $\pm .2$   
.XX  $\pm .06$   
.XXX  $\pm .010$   
ANGLES  $\pm 1/4^\circ$

8. BREAK ALL SHARP EDGES .02 RAD. OR CHAMFER  
EXCEPT AS NOTED
- 9 ALL MACHINED SURFACES TO BE  $\sqrt{32}$  UNLESS OTHERWISE  
NOTED.
- 10 DEVCON CORP  
DANVERS, MA 01923-3753  
CODE IDENT NO 16059
- 11 THE 145G0145-1 HOLDING FIXTURE HAS BEEN SUCCESSFULLY DEMONSTRATED  
PER FIT & FUNCTION DEMONSTRATION REPORT NO. 47-257F.

[illegible]

CUSTOMER SIGNATURE  
ON RECORD  
ONE-HALF SCALE  
COPY OF ORIGINAL DWG.

-	1	7	LIQUID RELEASE AGENT	DEVCON VACUUM (13)
-	1	16	DEVCON'S PLASTIC STEEL	DEVCON VACUUM (13)
-	1	15	BASE PL	WPS 3/1/2016 SC
-	1	14	MESCALO 4.0 SERCEL TAP	2 X 5/8" 1/2" CRES
-	1	13	2" PLUMING DOWEL	2 X 5/8" 1/2" CRES
-	1	12	2" PLUMING ALUM TOWEL	1 1/2" X 1 1/2" 1/2" CRES
-	1	11	2" KING	1 1/2" X 1 1/2" 1/2" CRES
-	1	10	2" KING	1 1/2" X 1 1/2" 1/2" CRES
-	1	9	CLAMP	3/8" X 1/2" 1/2" CRES
-	1	8	2" HD CP SCR	1 1/2" X 1 1/2" 1/2" CRES
-	1	7	2" RISER	1 1/2" X 1 1/2" 1/2" CRES
-	1	6	2" RISER	1 1/2" X 1 1/2" 1/2" CRES
-	1	5	2" HD CP SCR	1 1/2" X 1 1/2" 1/2" CRES
-	1	4	FLAT WASHERS	1 1/2" X 1 1/2" 1/2" CRES
-	1	3	2" HD CP SCR	1 1/2" X 1 1/2" 1/2" CRES
-	1	2	CLAMP	3/8" X 1/2" 1/2" CRES
-	1	1	PLASTIC ASSY	1 1/2" X 1 1/2" 1/2" CRES

DATA REVIEW		CONTRACT NUMBER		BOEING VERTEL COMPANY A Division of Boeing Company PHILADELPHIA, PENNSYLVANIA 19182	
INVOICE	DATE	DATE	NO.	<b>HOLDING FIXTURE —</b> <b>COLLECTOR GEAR.</b> <b>COAX XMEN</b>  <b>SIZE CODE IDENT NO</b> <b>J 77272</b> <b>145G0145</b>	
STAFF		DRAGNO-85-C-0005			
SALE PRICE		CHQ. <b>RA. HAPPEL</b> 545			
MTL		CHQ. <b>RA. HAPPEL</b> 545			
CHARTERED NUMBER		CHQ. <b>RA. HAPPEL</b> 545			
PIN	26300	CHQ. <b>RA. HAPPEL</b> 545		<b>J 77272</b> <b>145G0145</b>	
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-1	—	414-100	M4001-M4999	A	<p align="center"><b>BOMBING PROPRIETARY</b></p> <p>THE INFORMATION CONTAINED HEREIN IS PROPRIETARY TO THE BUREAU OF INVESTIGATION AND SHALL NOT BE REPRODUCED OR USED OUTSIDE OF THE BUREAU OF INVESTIGATION OR IN PART OR USED FOR ANY PURPOSE OR MANUFACTURE OF ANY TYPE WITHOUT THE EXPRESS WRITTEN PERMISSION OF THE BUREAU OF INVESTIGATION. ANY VIOLATION OF THIS POLICY SHALL BE CONSIDERED A VIOLATION OF THE FEDERAL BUREAU OF INVESTIGATION'S POLICY ON INFORMATION SECURITY.</p>
-1		CH-47D	M3004-M3999	A	
PART NUMBER	NEXT ASSY	USED ON	EFFECTIVITY	DWG SH NUMBER	REV
APPLICATION					